

750 .058W

Work Order ID 86858

86858

Page 1

July-06-12 3:16:10 PM

Item ID: D2973

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cross Bolt Spacer

Start Date: 7/06/12 Start Qty: 20.00

20

Cust Item ID:

Required Date: 8/10/12 Req'd Qty: 20.00

20

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan:

Date: 12-07-10

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2973

Rev A

100

0.00

100

Hardinge

Hardinge CNC Lathe Small

Memo

TURN AS PER DWG AND FOLIO FB096

DWG REV: A

FOLIO REV: N/A

0.00

DAS
13
2-89

12/7/22

22 0

105

QC2- Inspect parts off machine FAI/FAIB

0.00

105

QC

Quality Control

Memo

0.00

DAS
13
2-89

12/7/22

22 6

107

QC8- Inspect parts - second check

0.00

107

QC

Quality Control

Memo

0.00

DAS
14
2-89

12/07/22

22 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86858

86858

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July-06-12 3:16:10 PM

Item ID: D2973 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Cross Bolt Spacer
 Start Date: 7/06/12 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	Identify as per dwg & Stock Location: <u>LG</u>	0.00				22	0	BE 12/08/02	
120									
Packaging	Memo	0.00							
Packaging	***STOCK IN SKIDTUBE CELL***								
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

12/8/9 *[Signature]*
 me
 12-08-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86858

Parent Item: D2973

Parent Item Name: Cross Bolt Spacer

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A00.05.18New IssueEC
JLM VERIFIED BY:DD

IPP REV:B NOW ON HARDINGE 12.02.28

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.750W.058		Purchased	No			100	f	140.9500	0.2896	6.096842			
6061-T6 RD Tube .750 x.058W													

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT015	140.95	
10099	24	
112652	116.95	

M 9673

7PT

DAS
13
9-89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

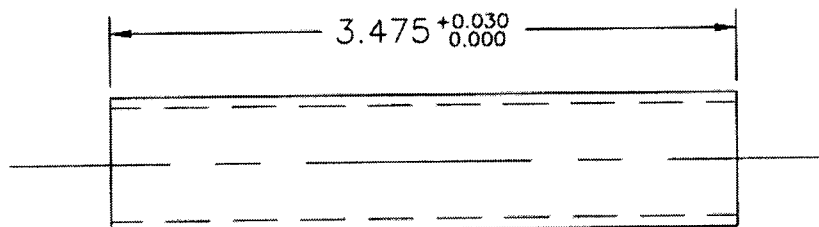
NOTE: Date & initial all entries



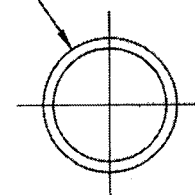
DESIGN <i>RF</i>	DRAWN BY <i>RF</i>	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2973	REV. A SHEET 1 OF 1
DATE 00.03.13		TITLE CROSS BOLT SPACER	SCALE 1:1
A	00.03.13	NEW ISSUE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86838 *pl 120210*

RELEASED
00.05.11 *[Signature]*



Ø0.750
(REF)



MATERIAL: 6061-T6 (WW-T-700/6) 0.750 DIA. x 0.058 WALL
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries